

5/45

133

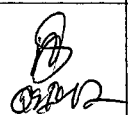
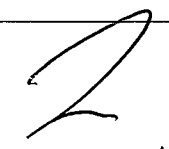
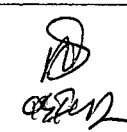
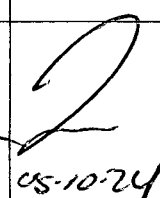
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24502
<b>Description:</b> Hinge Bracket	<b>Part Number:</b>	D2857-2
04.08.17 <i>ky</i> 04.08.17 <i>CP</i>		
<b>Drawing:</b> D2857 Rev. A1	<b>Qty:</b>	24

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	<i>CH</i>	05.10.12	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch <i>M108/8</i>	<i>SD</i>	05.10.12	24
3	HAAS	Machine per folio D2857-2	<i>BC</i>	05.10.12	24
4	QC	Inspect Level 2	<i>BC</i>	05.10.12	24
5	METAL	Tumble <i>N/A</i> Deburr any rough edges after tumbling	<i>BC</i>	05.10.12	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	<i>SAD</i>	05/11/12	24
7	QC	Inspect Level 7	<i>ML</i>	05/11/12	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	<i>MM</i>	05/11/12	24
9	QC	Inspect Level 3	<i>CL</i>	05/11/12	24
10	STORES	Identify and stock	<i>LC</i>	05/11/12	24
11	EXPEDITING	Close W/O Cost / Part: <i>LOC: 114</i> <i>545 05/11/12</i>	<i>LC</i>	05/11/12	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	<i>EC</i>

**RELEASED**  
JUN 26 2000  
*EC*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.10.23	3	Dim .376" is .356 Program Error		Program Corrected Destroy + Replace	BG 05.10.24	 05.10.24		 05.10.24

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/20

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	24502
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857	Rev: A1	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.309	✓			
0.340	+/-0.010	.345	✓			
1.110	+/-0.005	1.108	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.007	✓			
Ø0.171	+0.005/-0.000	.172	✓			
0.147	+/-0.010	.146	✓			
0.376	+/-0.010	.369	✓			
0.126	+/-0.010	.126	✓			
0.611	+/-0.010	.611	✓			
0.063	+/-0.010	.065	✓			
0.166	+0.005/-0.000	.167	✓			
0.911	+/-0.010	.914	✓			
0.600	+/-0.010	.603	✓			
0.125	+/-0.010	.133	✓			
0.150	+/-0.010	.155	✓			

Measured by:	BG
Date:	05.10.23

Audited by:	SA
Date:	05.10.23

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	

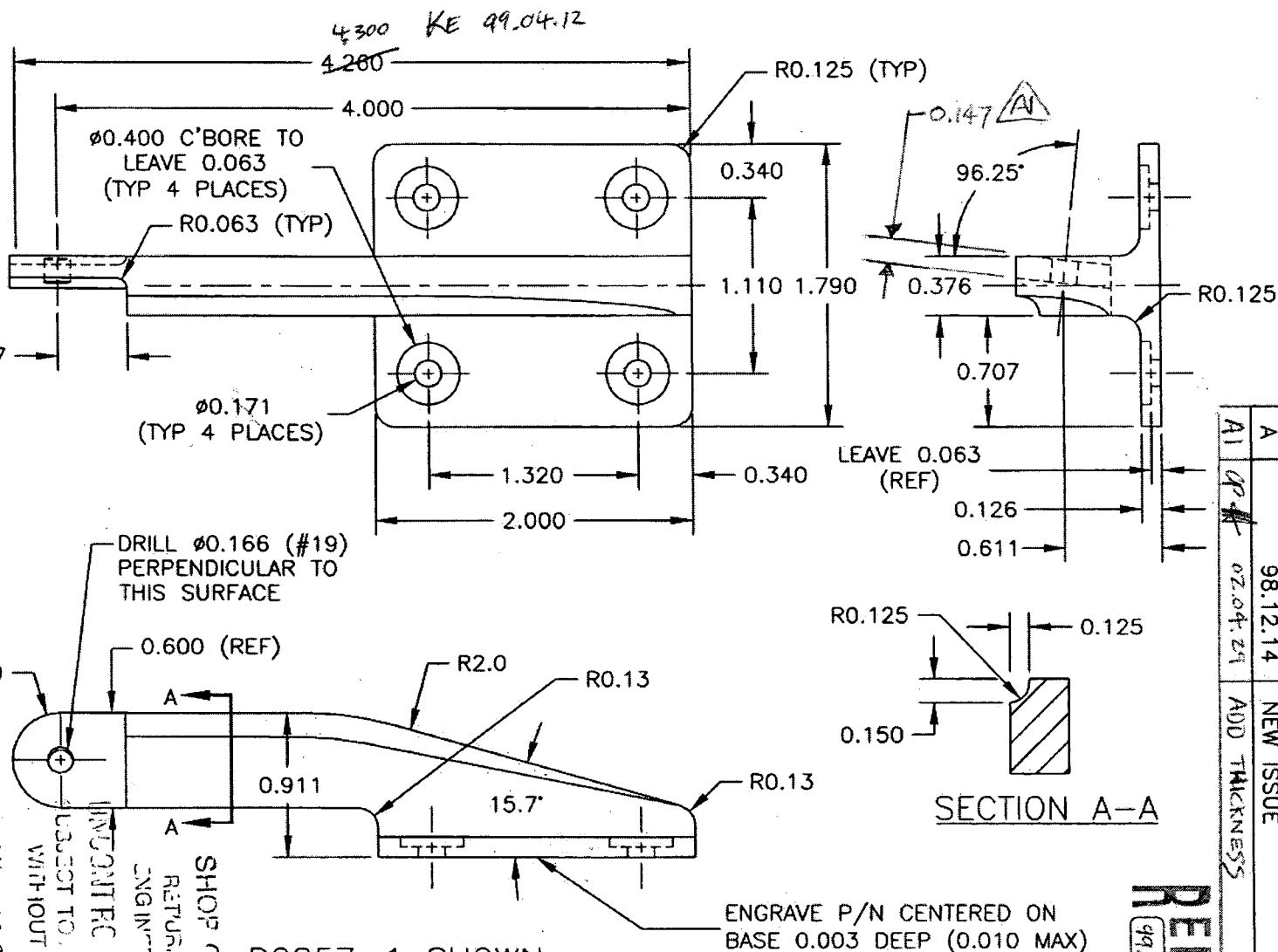
RELEASED  
04.06.17

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	SP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	SP	D2857
DATE	TITLE	REV. A
98.12.14	HINGE BRACKET	SHEET 1 OF 1
A	98.12.14	NEW ISSUE
A1	02.04.29	ADD THICKNESS

**RELEASED**  
99.01.06 KE



D2857-1 SHOWN  
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER

NO. 24502

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 11, 2005  
07:41 am

Work Order No : 0024502  
Project Name : D2857-2  
Project For : WK545  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2857-2  
Description : Hinge Bracket  
Manufactured : Yes  
Amount Req'd : 24  
Amount Done : 0  
Start Date : 10-08-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:21 pm

Work Order No : 0024502  
Project Name : D2857-2  
Project For : WK545  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2857-2  
Description : Hinge Bracket  
Manufactured : Yes  
Amount Req'd : 24  
Amount Done : 0  
Start Date : 10-08-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	15.00	100.00		
Production Cost :	0.00	361.65	100.00	0.00	361.65
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	15.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	361.65	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	361.65			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -361.65)

*MIS 8/B*  
*u*  
*11.13*

Date: Monday, 14/11/2005 8:28:56 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HINGE BRACKET
<b>Job Number</b>	: 24502		
<b>Estimate Number</b>	: 10347		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D28572
<b>This Issue</b>	: 14/11/2005	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2857 REV A1
<b>First Issue</b>	: / /	<b>Project Number</b>	:
<b>Previous Run</b>	:	<b>Drawing Revision</b>	: A1
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 30/11/2005
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	24 Um: Each
<b>Comment</b>	: Est C 00.06.22 Removed P/O for powder coat EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks 5.2"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine per folio D2857-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 1-Tumble  
 2-Deburr any rough edges after tumbling

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Acid etch and Alodine as per QSI 005 4.3

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 24502

Part Number: D28572

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

